

Work Order ID 56733

March 5, 2010 9:59:52 AM



Page 1

Item ID: D3391-015

Accept



Setup Start

Revision ID:

Item Name: Aft Tube Assembly

Stop

Start Date: 05/03/2010 Start Qty: 1.00

Required Date: 17/03/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: PL

Date: 10-3-05

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: H

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10/5/20 AUTH ELX

RELEASED DATE

120

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: H
2-Deburr

10/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

OK 10/03/29

1 0

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

OK 10/03/31

1 0

150

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

1 M 10/4/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391								
170		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

h=4.125"

8/10/2013

70

1 10/4/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8808 (ALL HOLES)

3-Drill and c'bore wearshoe holes as per Dwg *****ensure wall thickness after c'bore is no less than 0.051*****

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391
Deburr

5- Tranfer holes from D3391-013 for electric step in tube

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

M121513

10-5-4

8/6/10/4

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 11/05/15

210

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Install crossbolt spacers per dwg D3391
A/R Magnabond 6398 batch: M114021

11/05/15

2- Grind flush

Ex2. 11/6/30
11/05/16

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/05/106

④

Re-align as per 09-043 ml 10.08.16 ①

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Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation

Description

M115291

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:00AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:30AM

=> M 10/08/17

1 0

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M 10 08 17 (1)

250

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts per dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291 M115114

Sikaflex expiry date: 11/01

=> M 10/08/17

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				ml	10	08	18 ①
Quality Control									
270	Identify as per dwg & Stock Location: <u>WB 56719 mm</u>	0.00							
Packaging	Memo	0.00				ml	0	08	18 ①
Packaging									
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/08/30

MF
10-8-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56733



Parent Item: D3391-015

Parent Item Name: Aft Tube Assembly

Start Date: 05/03/2010

Required Date: 17/03/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 05.12.13 New issue EC
IPP rev B 06.02.09 Dwg @ revD EC
IPP rev C 07.03.13 dwg @revF ec
IPP rev D 07.10.31 ecn 1053P EC

AN960C10L

Purchased No

100

Each

388.0000 10.0000



washer

*NAS 1149C0332R

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

M115000

X10

91 10/08/17

103585

100

Main Warehouse

ST

288

112116

128

112612

160

D6014-090

Manufactured No

210

Each

7.0000

1.0000



ALUMINUM EXTRUSION

mb 10-03-17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

7

42768

7

24

March 5, 2010 9:59:50 AM

Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56733



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Parent Item Name: Aft Tube Assembly

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP rev A 05.12.13 New issue EC
 IPP rev B 06.02.09 Dwg @ revD EC
 IPP rev C 07.03.13 dwg @revF ec
 IPP rev D 07.10.31 ecn 1053P EC

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

1,142.000 14.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1142

1114723

X14 M 10/08/17

110511

1142

ALS4-1032-225

Purchased

No

250

Each

6,116.000 12.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6116

107441

16

110768

6100

X12 M 10/08/17

ALS4-428-165

Purchased

No

250

Each

30.0000 4.0000



Inserts

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

30

6989

30

X4 M 10/08/17

March 5, 2010 9:59:50 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item Name: Aft Tube Assembly

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP rev A 05.12.13 New issue EC
 IPP rev B 06.02.09 Dwg @ revD EC
 IPP rev C 07.03.13 dwg @revF ec
 IPP rev D 07.10.31 ecn 1053P EC

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

250

Each

1,649.000 6.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1649

xx 114941

x6

u 10/08/17

112314

13

112720

12

112724

3

112829

1

112991

2

113121

64

113226

344

113644

110

113749

100

114103

500

114108

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Comments: IPP rev A 05.12.13 New issue EC
IPP rev B 06.02.09 Dwg @ revD EC
IPP rev C 07.03.13 dwg @revF ec
IPP rev D 07.10.31 ecn 1053P EC

Start Date: 05/03/2010

Required Date: 17/03/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased No

250

Each

587.0000 4.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

587

1115015

vd M 10/08/17

111424

8

111707

69

112314

1

113121

49

113149

160

114056

200

114108

100

D2646

Manufactured No

250

Each

48.0000 1.0000



Aft Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP6

29

B57332

x1 M 10/08/17

52663

29

Main Warehouse

fp7

11

52663

11

Main Warehouse

ST

8

46327

4

48109

4

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 IPP rev C 07.03.13 dwg @revF ec
 IPP rev D 07.10.31 ecn 1053P EC

Start Date: 05/03/2010

Required Date: 17/03/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No

250 Each 85.0000 1.0000



Wearpad



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

74

B 60192

xl 10/08/17

48288

2

55465

72

Main Warehouse

FP17

11

51678

1

51679

10

D3537-7 Manufactured No

250 Each 14.0000 1.0000



Wearpad



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

14

45408

3

46346

11

yt

10/08/17

March 5, 2010 9:59:51 AM

Shop Packet Print

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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IPP rev C 07.03.13 dwg @revF ec
IPP rev D 07.10.31 ecn 1053P EC

Start Date: 05/03/2010

Required Date: 17/03/2010

Start Qty: 1.00

Required Qty: 1.00

D3553-1 Manufactured No



Gasket

250 Each 9.0000 1.0000



Warehouse
Location

Main Warehouse

ST 9

33868

9

D3553-3 Manufactured No



Gasket

250 Each 58.0000 1.0000



✓ 10/08/17

Warehouse
Location

Main Warehouse

FP 58

53480

58

D3670-4-200 Manufactured No



SPACER

250 Each 63.0000 14.0000



✓ 10/08/17

Warehouse
Location

Main Warehouse

ST 63

48198

4

48269

59

B56801

(14)

11/05/15

March 5, 2010 9:59:51 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Required Date: 17/03/2010

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 IPP rev B 06.02.09 Dwg @ revD EC
 IPP rev C 07.03.13 dwg @revF ec
 IPP rev D 07.10.31 ecn 1053P EC

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

250

Each

1,618.000 2.0000



Phenolic Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1118

39275

19

42329

5

47628

94

52505

1000

Main Warehouse

ST117

500

51674

500

x2 JU 10/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART AEROSPACE LTD		Work Order:	56733
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391 Rev: H		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓			
3.500	+/-0.010	3.498	✓			
88.93	+/-0.030	88.9375	✓			
44.995	+/-0.030	45.000	✓			
Ø3.200	+/-0.010	3.200	✓			
88.93	+/-0.030	88.9375	✓			
Ø3.750	+/-0.010	3.75	✓			
30° x 160° chamfer	+/-0.010	30° x 160°				

Measured by: *AMH / O.M.* **Date:** _____

Audited by: *-10-03-23* **Date:** _____

HAAS Section						
1.526	+0.000/-0.030	1.503	✓			
7.500	+/-0.010	7.497	—			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	25.250	—			
3.300	+/-0.010	3.294	✓			
0.200	+/-0.010	.204	—			
3.520	+/-0.010	3.524	—			
0.687	+0.010/-0.000	.687	—			
R0.062	+/-0.010	R.062	—			
Ø0.484	+0.005/-0.001	Ø.489	✓			

Measured by: *AMH* **Date:** *10/03/29*

Audited by: *J.P.* **Date:** *10/03/31*

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	<i>AA</i>

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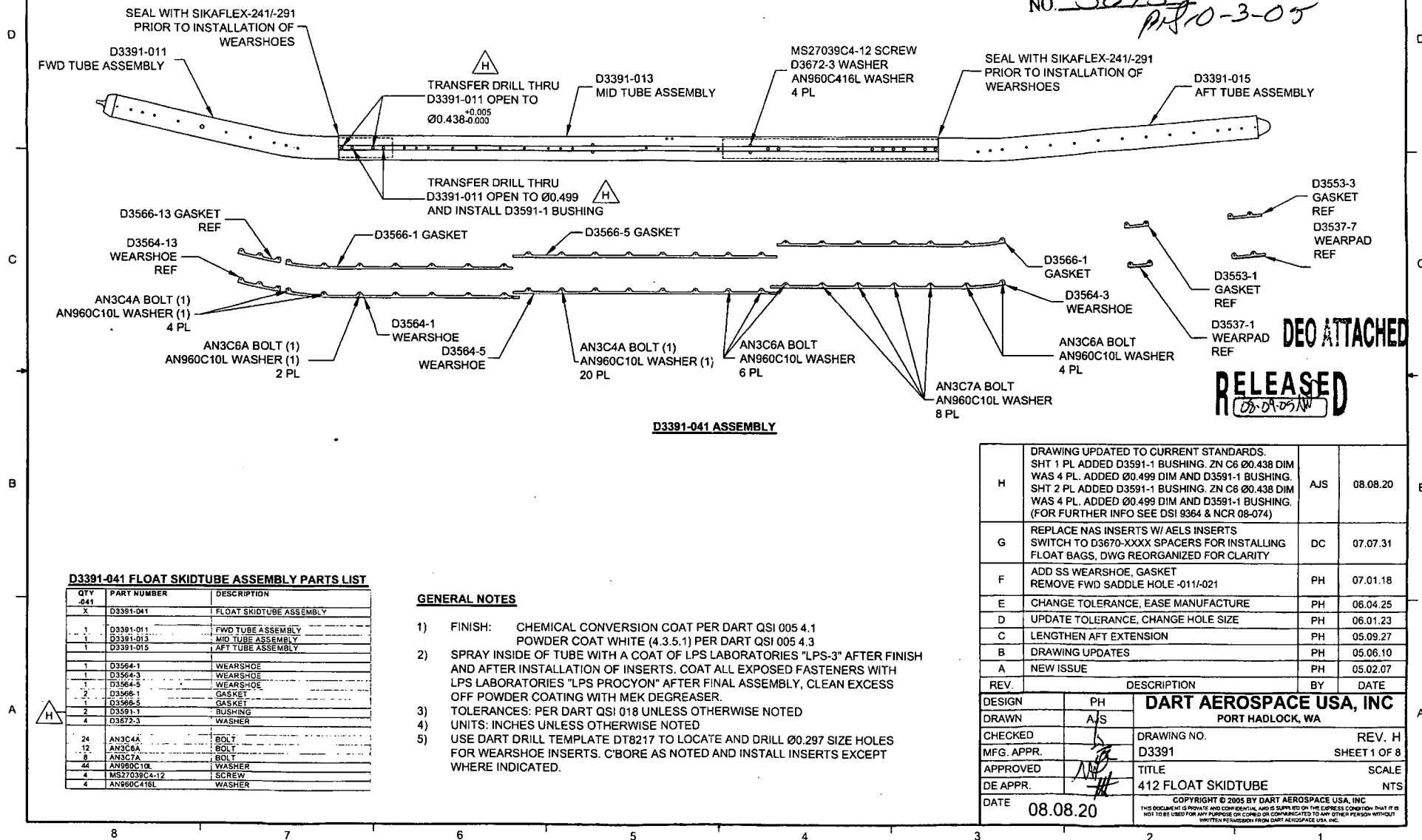
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 56733

P10-3-05







D3391-041 ASSEMBLY

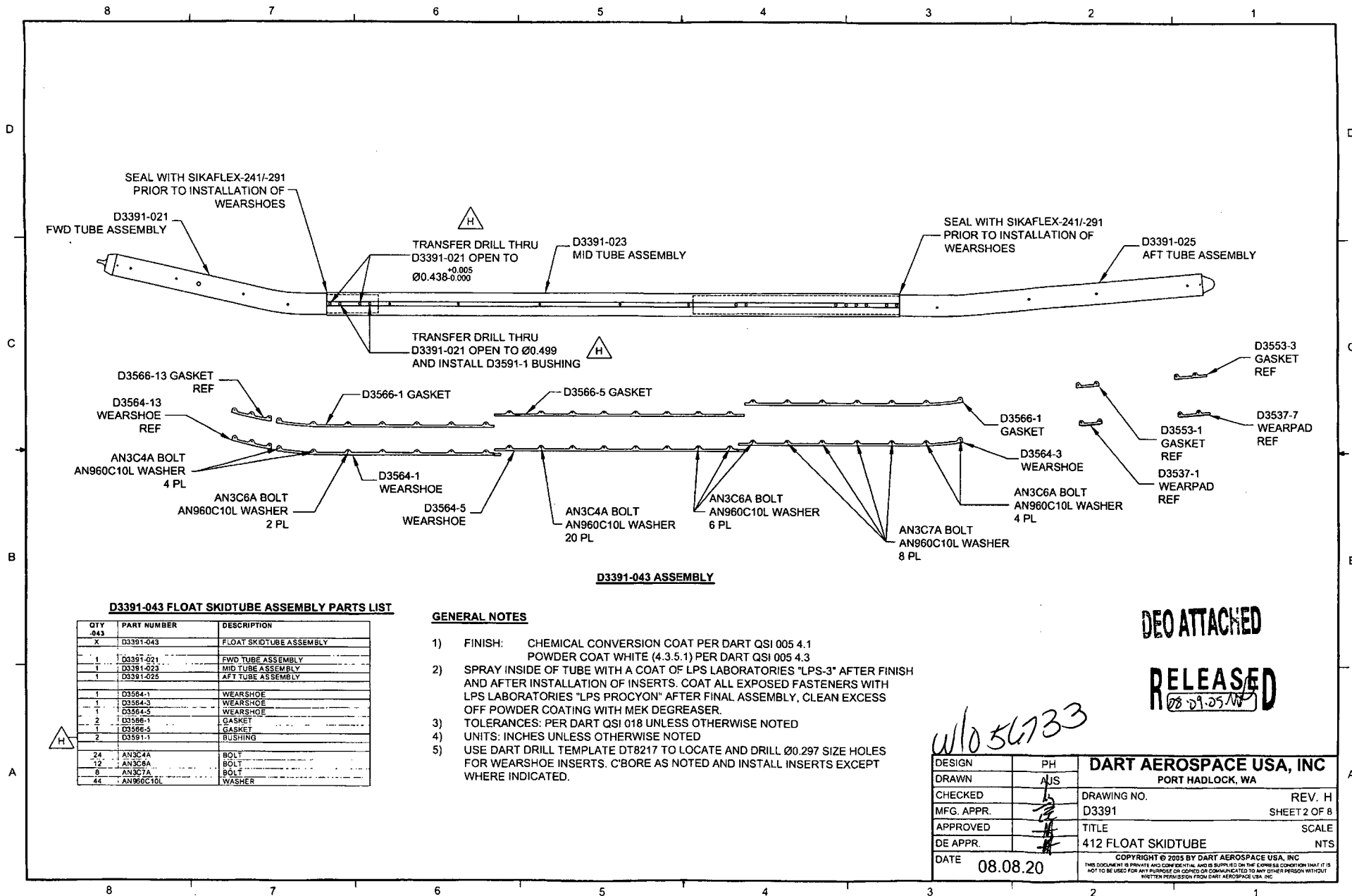
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

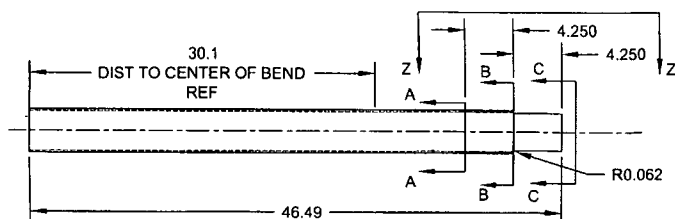
QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
2	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

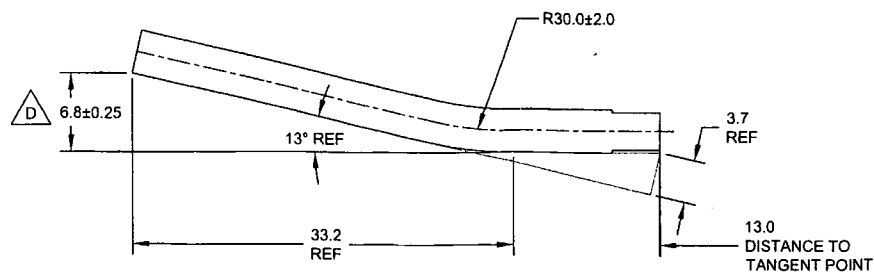
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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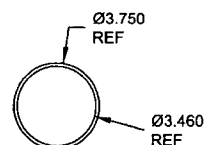




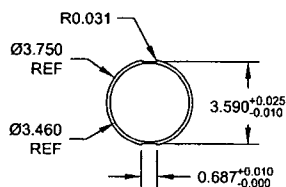
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



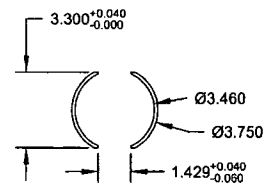
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



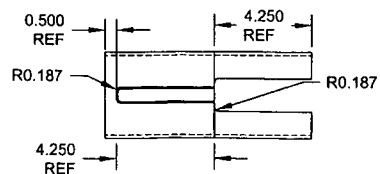
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

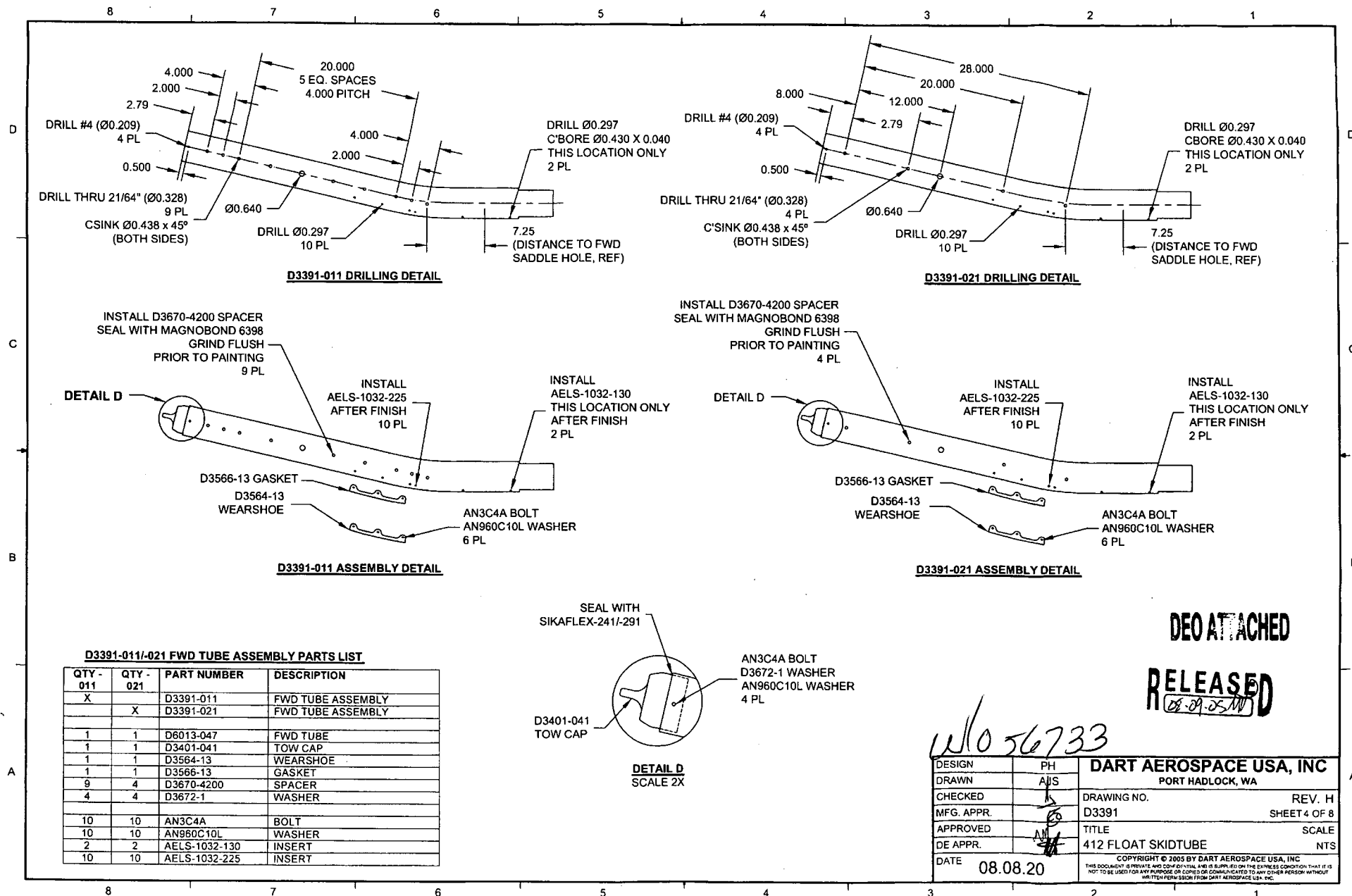


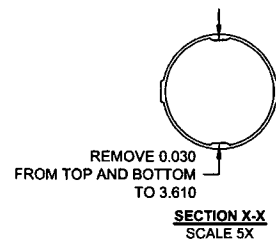
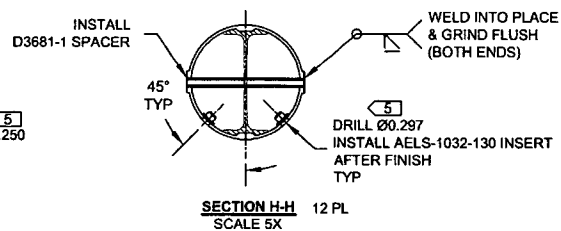
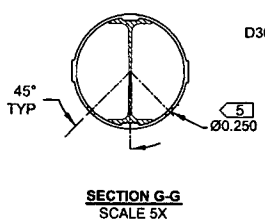
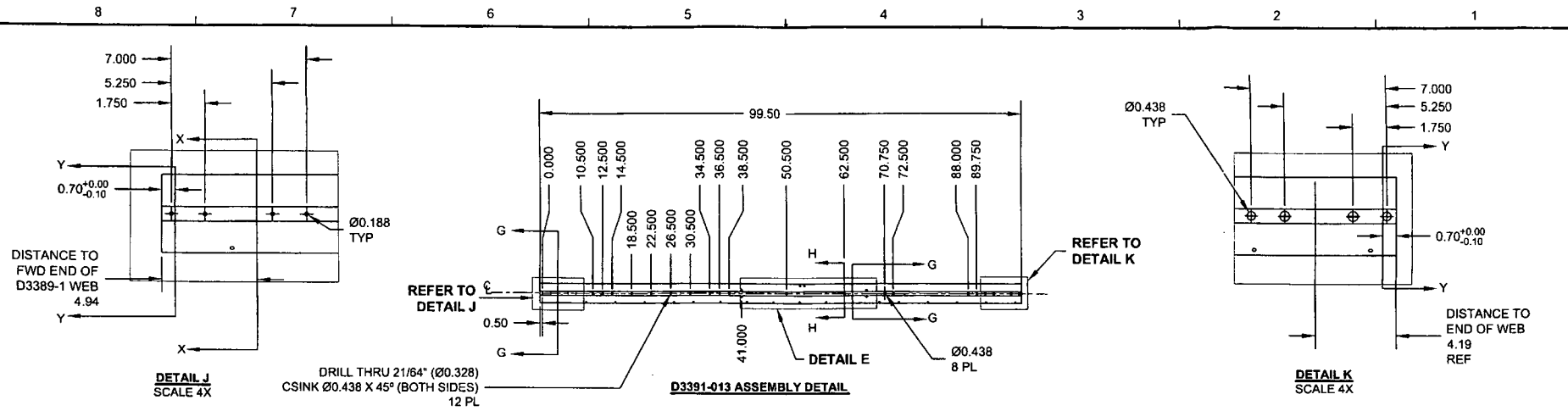
VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
2005-05-11

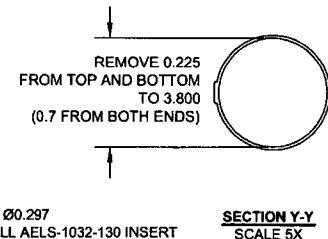
W1056733

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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
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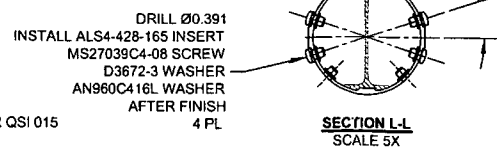
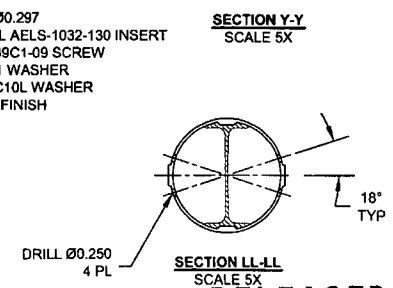
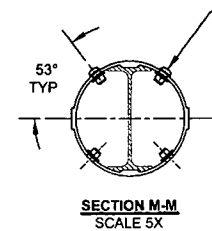
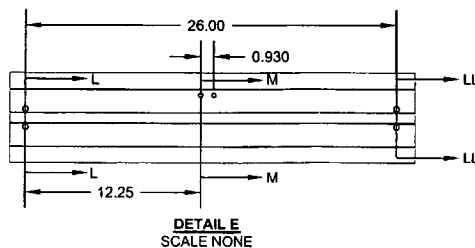


w/056733



D3391-013 MID TUBE ASSEMBLY PARTS LIST

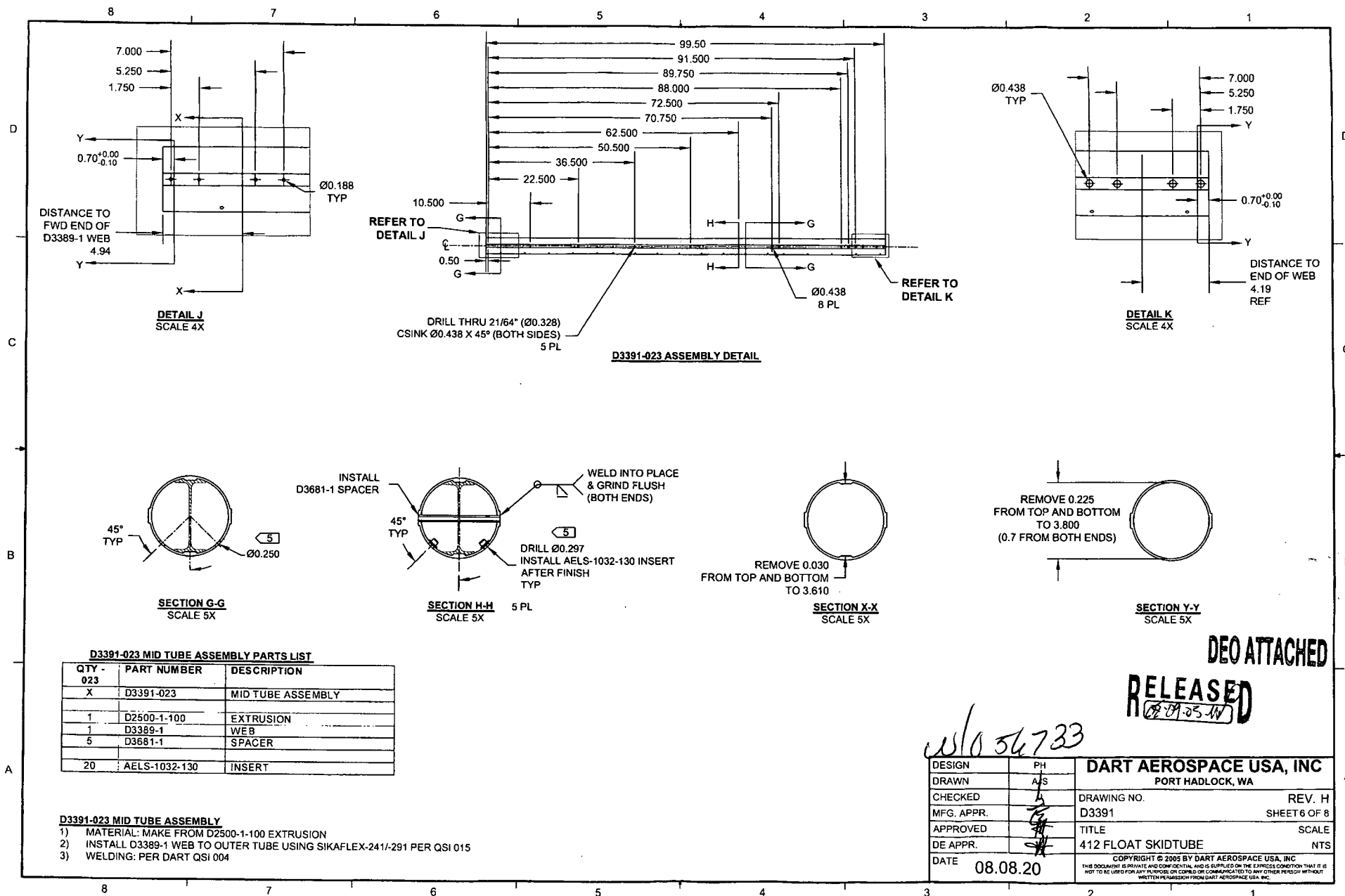
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

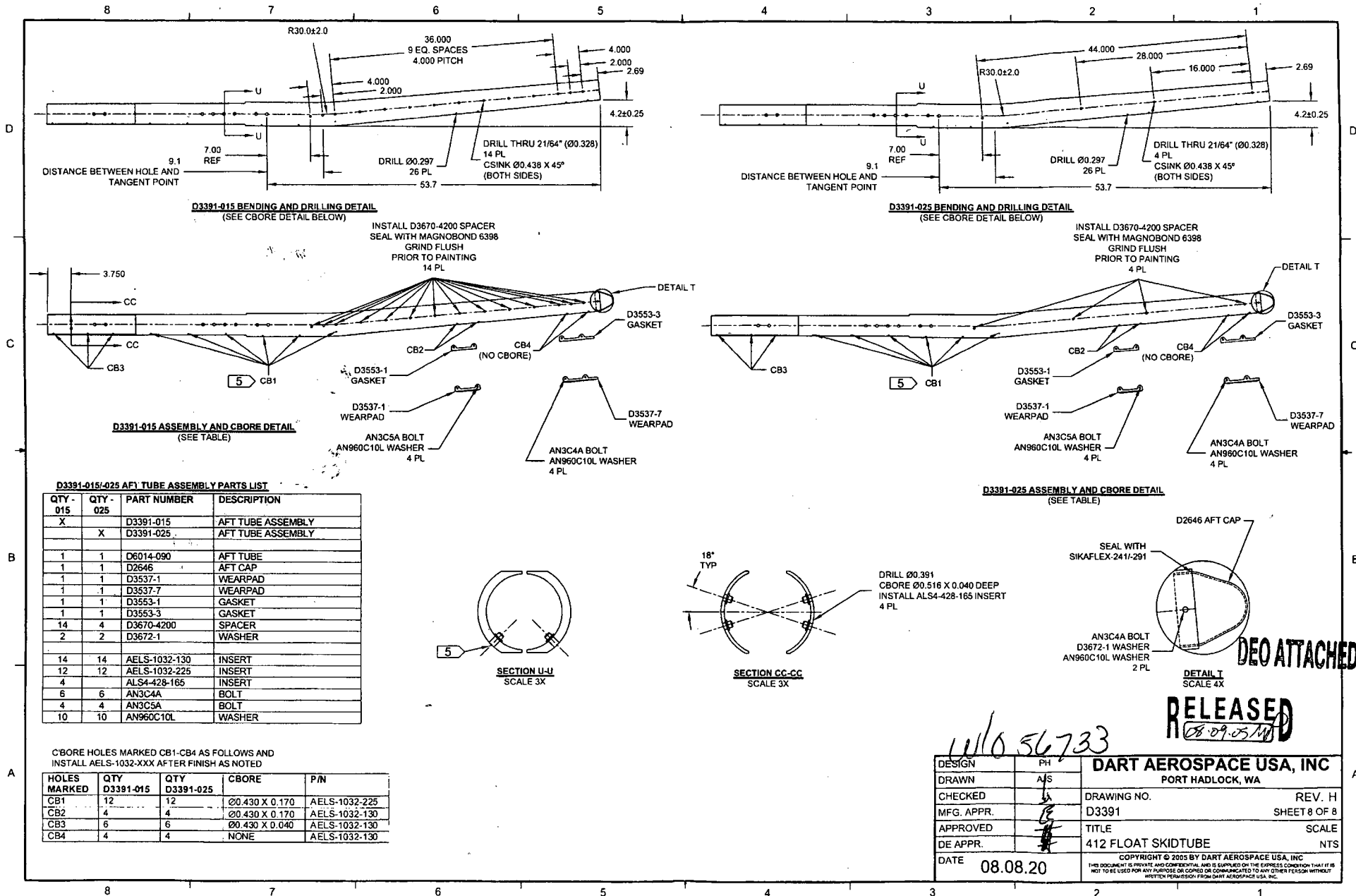


DEO ATTACHED **RELEASED**

- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 04.04.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

w/o 54733

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